

2/01/2009 8:00:55 AM

Process Sheet

DAR001 Dart Helicopters Services Drawing Name : FWD ADJUSTABLE BLADE SUPPORT ASSY
 45041
 : 13433
 :
 : 22/01/2009 S.O. No. :
 : NC
 : 11 Type : LARGE FAB ASSY
 Previous Run : 43059
 Part Number : PB674300115
 Drawing Number : B6743001 P.7
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 28/01/2009 Qty: 9 Um: Each
 Written By :
 Checked & Approved By : MF 09-01-22
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB6743001257	Inner Tube
2.0	PB6743001249	Inner Tube Bushing
3.0	PB6743001253	Gusset
4.0	PB6743001254	Gusset
5.0	PB674300171	PB67-43001-71



Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Inner Tube

batch: B414950MF 09-02-18

Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Inner Tube Bushing

batch: B41871MF 09-02-18

Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Gusset

batch: B41492MF 09-02-18

Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Gusset

batch: B41493 x 4, 44982 x 5MF 09-02-18

Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

PB67-43001-71

batch: B41512 x 2, 40027 x 4, B41512 x 3MF 09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 45041

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

SP 09.02.24 (9X)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ZE 09-02-25 (9X)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 09/02/25 (X9)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)
HELICAL INSERT

M 110768

MF 09-02-18

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only
- 2- install helicol insert as per dwg

SP 09-02-26 9

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 09/02/26 (X9)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 110768

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

- 1- MASK TUBE FROM BASE TO GUSSET

- 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

SP 09-02-27 (X9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 8:00:55 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 45041

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

9:00AM

OVEN TEMPERATURE:

320°C

FINISH TIME:

9:30AM

24 09-02-27

(14)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 09-02-27

15.0

PB674300173

20 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)
20 Degree Cover Plate
batch: 41513

MF 09-03-09

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)
PB67-43001-83
batch: 415072

MF 09-03-09

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 72.0000 Each(s)
Screw
batch: 110781

MF 09-03-05

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 72.0000 Each(s)
WASHER
batch: 110704 x 22 M108100 x 50

MF 09-03-05

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support
2- assemble as per dwg

QAD 07-03-07 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 8:00:55 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 45041

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

090309 (9)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST - Blade fold section

MF 090309

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10

Job Completion



MF 09-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

